

Work Order ID 61650

Tuesday, August 31, 2010 9:49:47 AM



Page 1

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2010

Start Qty: 1.00

Cust Item ID:

Required Date: 9/7/2010

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 61650 Double check by: ☐ 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA641 and inspect p

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

[illegible]

Page 2



Stop

[illegible]

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Customer:



Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

**Insp.
Stamp**

$\Rightarrow M 10/10/00$

0.00

Hand Finishing

0.004

0.00

START TIME: 10:25 OVEN TEMPERATURE: 320
FINISH TIME: 10:55

0.00



0.00

Quality Control

Work Order ID 61650

Tuesday, August 31, 2010 9:49:47 AM



Page 3

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 424

0.00



Packaging

Memo

0.00

Packaging

10/10/05 (25)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05

10/10/05

Picklist Print

Tuesday, August 31, 2010 9:49:52 AM

Page 1

Work Order ID: 61650

Parent Item: D3500-1

Parent Item Name: Saddle



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 Saddle Billet		Manufactured	No			100	Each	11.0000	1	<u>25</u>		10/09/23	

Location

Loc Qty

Loc Code

MAT43

11

59467

3

60713

8

61300

26

25

DART AEROSPACE LTD		Work Order:	61650
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488	DJP-II	Vern
B	1.175	1.185		1.180	1.180	1.180	1.180		"
C	3.145	3.155		3.150	3.150	3.150	3.150		"
D	1.175	1.185		1.180	1.180	1.180	1.180		"
E	0.365	0.385		0.385	0.380	0.380	0.380		"
F	0.490	0.510		0.499	0.499	0.499	0.499		"
H									
I	R1.575	R1.595		1.5845	1.5895	1.5885	1.588		Dial
J	0.240	0.260		0.248	0.248	0.248	0.248	DJP-II	Vern
K	0.490	0.510		0.499	0.500	0.499	0.500		"
L	3.590	3.650		3.620	3.620	3.620	3.620		"
M	0.315	0.322		0.318	0.318	0.318	0.318		"
N	0.256	0.262		0.260	0.260	0.260	0.260		"
O	6.500	6.520		6.510	6.510	6.510	6.510	CNC-02	Vern
P	5.990	6.010		5.995	5.995	5.995	5.995		"
Q	2.820	2.830		2.825	2.825	2.825	2.825	DJP-II	Vern
R	2.495	2.505		2.500	2.500	2.500	2.500		"
S	2.245	2.255		2.250	2.250	2.250	2.250		"
T	1.120	1.130		1.125	1.125	1.125	1.125		"
U	0.540	0.560		0.545	0.545	0.547	0.547		"
V	0.793	0.803		0.798	0.798	0.798	0.798		N/A
W	R.240	R.260		0.250	0.250	0.250	0.250		Rad Gage
X	0.040	0.060		0.060	0.060	0.060	0.060	DJP-II	Vern
Y	0.100	0.120		0.110	0.110	0.110	0.110		"
AA	R1.125	R1.145		1.1345	1.1375	1.136	1.136		Dial
AB	R.490	R.510		0.500	0.500	0.500	0.500		Rad Gage
AC	0.615	0.635		0.635	0.635	0.635	0.635	DJP-II	Vern
AD	0.240	0.260		0.253	0.253	0.253	0.253		"
AE	1.810	1.830		1.821	1.827	1.827	1.827		"
AF	0.240	0.260		0.251	0.252	0.251	0.251	DJP-02	Mic
AG	0.140	0.160		0.150	0.152	0.151	0.151		"
AH	0.140	0.160		0.155	0.148	0.148	0.148	118-120	Deep Mic
AI	0.140	0.160		0.158	0.154	0.155	0.155		"
Accept/Reject									

Measured by:	DJP
Date:	10/09/23

Audited by:	H.A
Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41450
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.498	0.499	0.498		
H									
I	R1.575	R1.595		1.588	1.588	1.587	1.5885		
J	0.240	0.260		0.247	0.248	0.248	0.248		
K	0.490	0.510		0.499	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.995	5.995	5.995		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.547	0.545	0.545		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.060	0.060	0.060	0.060		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.135	1.135	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.252	0.253	0.253	0.253		
AE	1.810	1.830		1.827	1.827	1.827	1.826		
AF	0.240	0.260		0.251	0.250	0.250	0.251		
AG	0.140	0.160		0.151	0.150	0.150	0.151		
AH	0.140	0.160		0.150	0.148	0.149	0.150		
AI	0.140	0.160		0.153	0.156	0.155	0.156		
Accept/Reject									

Measured by: JTD
Date: 10/09/24

Audited by: H.A
Date: 10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD				Work Order: 61650	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500				Rev: C	
				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.584	1.586	1.587	1.587		
J	0.240	0.260		0.247	0.248	0.247	0.249		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.995	5.995	5.995	5.995		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.543	0.543	0.545	0.544		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.139	1.1355	1.136	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.253	0.251	0.252		
AE	1.810	1.830		1.826	1.826	1.825	1.826		
AF	0.240	0.260		0.251	0.251	0.251	0.251		
AG	0.140	0.160		0.150	0.151	0.150	0.151		
AH	0.140	0.160		0.150	0.149	0.148	0.148		
AI	0.140	0.160		0.155	0.157	0.156	0.154		
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 10/09/30

Audited by: H. A
Date: 10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 61650
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.499	0.500	0.500		
H									
I	R1.575	R1.595		1.587	1.587	1.587	1.586		
J	0.240	0.260		0.247	0.247	0.247	0.248		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.998	6.000	5.998		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.545	0.544	0.543		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.135	1.136	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.252	0.251	0.251		
AE	1.810	1.830		1.826	1.826	1.825	1.825		
AF	0.240	0.260		0.251	0.251	0.250	0.250		
AG	0.140	0.160		0.151	0.152	0.150	0.150		
AH	0.140	0.160		0.149	0.150	0.150	0.150		
AI	0.140	0.160		0.156	0.153	0.154	0.154		
Accept/Reject									

Measured by: <u>DT</u>
Date: <u>10/09/28</u>

Audited by: <u>H.A</u>
Date: <u>10/09/30</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	61650
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	18	19	20		
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.586	1.586	1.586	1.587		
J	0.240	0.260		0.247	0.247	0.248	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.998	5.998	5.996	5.996		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.545	0.543	0.543	0.543		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.135	1.136	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.251	0.251	0.251		
AE	1.810	1.830		1.825	1.825	1.825	1.826		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.149	0.153	0.149	0.149		
AI	0.140	0.160		0.153	0.155	0.153	0.153		
Accept/Reject									

Measured by:	JTP
Date:	10/09/28

Audited by:	H. A
Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	61650
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				21	22	23	24		
A	0.483	0.490		0.488	0.488	0.488	0.488		Vern JL3
B	1.175	1.185		1.180	1.180	1.180	1.180		"
C	3.145	3.155		3.150	3.150	3.150	3.150		"
D	1.175	1.185		1.180	1.180	1.180	1.180		"
E	0.365	0.385		0.380	0.380	0.380	0.380		"
F	0.490	0.510		.501	.502	.502	.501		"
H									
I	R1.575	R1.595		1.587	1.588	1.589	1.588		Dial
J	0.240	0.260		.251	.250	.250	.251		Vern JL3
K	0.490	0.510		.502	.502	.502	.500		"
L	3.590	3.650		3.620	3.620	3.620	3.620		"
M	0.315	0.322		0.318	0.318	.318	.318		"
N	0.256	0.262		0.260	0.260	.258	.258		"
O	6.500	6.520		6.510	6.510	6.509	6.510		"
P	5.990	6.010		5.998	5.998	5.998	5.998		"
Q	2.820	2.830		2.825	2.825	2.825	2.825		"
R	2.495	2.505		2.500	2.500	2.500	2.500		"
S	2.245	2.255		2.250	2.250	2.250	2.250		"
T	1.120	1.130		1.125	1.125	1.125	1.125		"
U	0.540	0.560		.544	.546	.548	.547		"
V	0.793	0.803		0.798	0.798	.798	.798		"
W	R.240	R.260		0.250	0.250	.250	.250		R-GT
X	0.040	0.060		.050	.050	.050	.050		Vern JL3
Y	0.100	0.120		.110	.110	.110	.110		"
AA	R1.125	R1.145		1.135	1.135	1.136	1.136		dial
AB	R.490	R.510		0.500	0.500	.500	.500		R-GT
AC	0.615	0.635		0.635	0.635	.635	.635		Vern JL3
AD	0.240	0.260		.253	.255	.253	.253		"
AE	1.810	1.830		1.825	1.826	1.825	1.826		"
AF	0.240	0.260		0.250	0.251	.251	.252		"
AG	0.140	0.160		0.150	0.150	.150	.149		"
AH	0.140	0.160		.150	.151	.151	.151		"
AI	0.140	0.160		.153	.154	.152	.153		"
Accept/Reject									

Measured by:	JL
Date:	10/09/29 / 10/08/30

Audited by:	H.A
Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

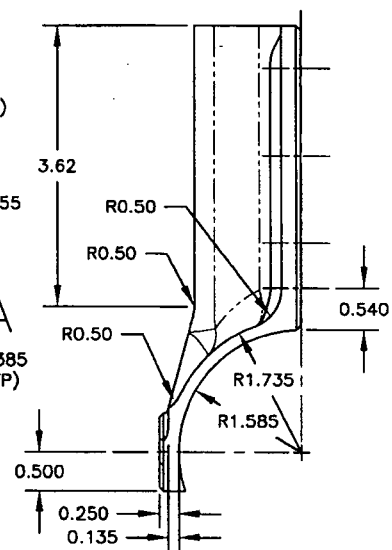
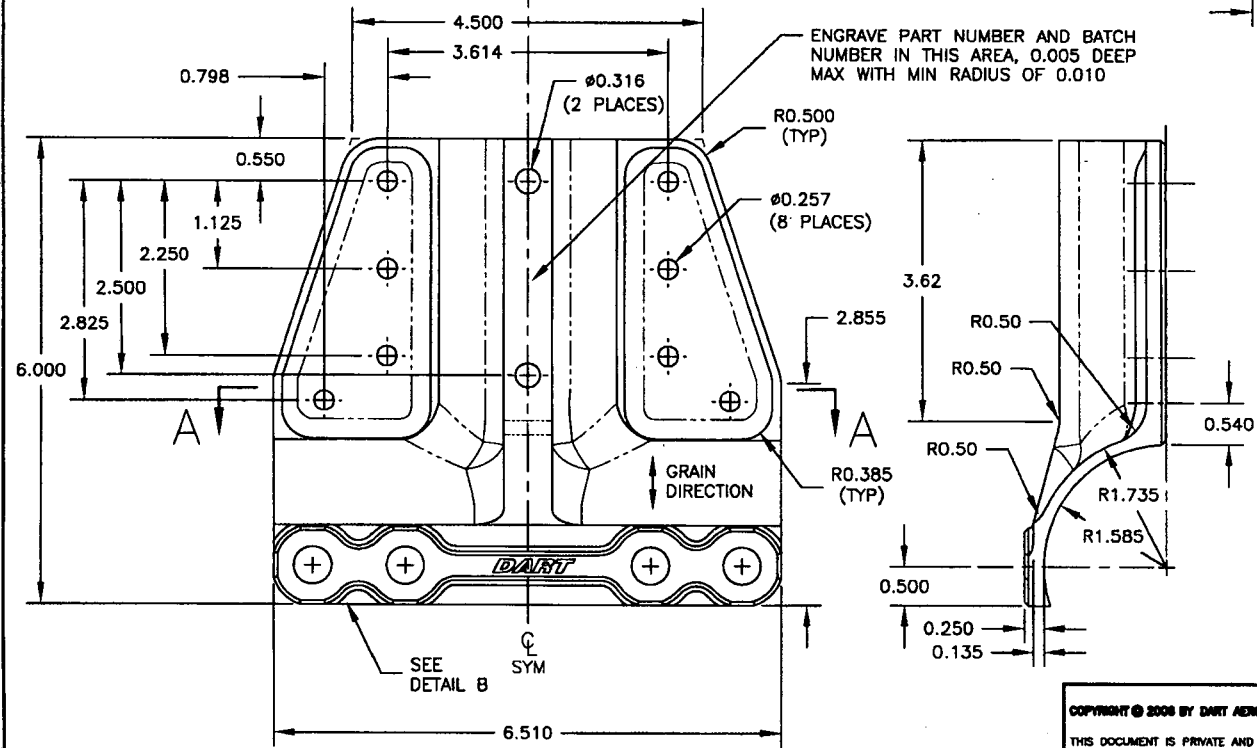
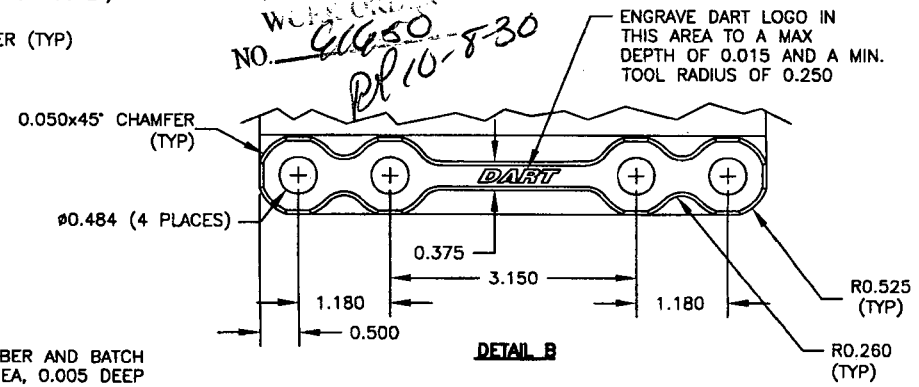
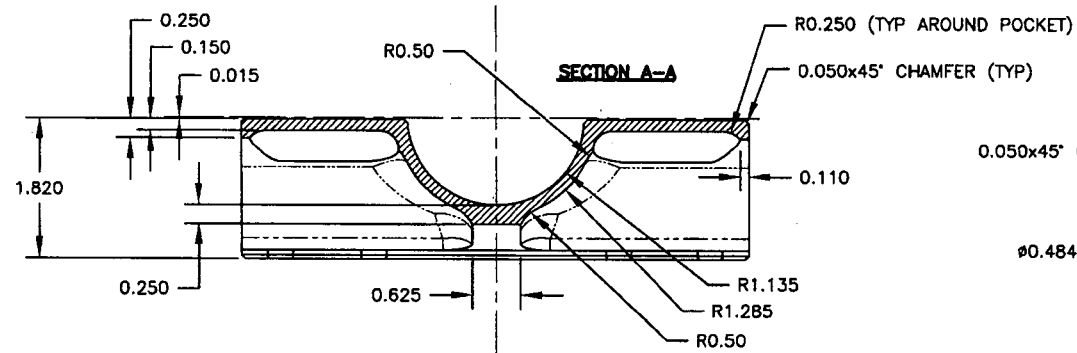
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RETURN TO

ENGINEERING

UNCONTROLLED
SHEET 1 OF 1

NO. *60650-830*
PL 10-830



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-68-15

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	<i>GP</i>	DRAWN BY <i>PH</i>
CHECKED	<i>#</i>	APPROVED <i>#</i>
DATE	06.06.30	TITLE SADDLE
DRAWING NO.	D3500	REV. C
DART AEROSPACE LTD.	WILLOWBURT, ONTARIO, CANADA	SHEET 1 OF 1
		SCALE 2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries